

Work Order ID 150441

Wednesday, August 24, 2016 11:57:14 AM

150441

Page 1

Item ID: D119-796-151

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: FWD Crosstube Installation with Step (no hardware)

Start Date: 8/16/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/12/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: **DAS 21** Date: **AUG 29 2016**

Tooling:

Date:

Run Start

NR1QC: **9-89** Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D119-796-151	D								

110 Document Control 0.00

110

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels as per PPP D119-796-151 chg 004

N/A 

120 Pick Kit 0.00

120

Packaging

Packaging

Memo

0.00

Packaging

/


16.11.27

130 Crosstubes 0.00

130

Crosstubes

Crosstubes

Memo

0.11

Crosstubes

1- Install step and clamp with the proper position per dwg D119-796-151

Torque all clamps to 50 IN-LBS max.

/


16.11.27

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control	***RE-CHECK TORQUE ON CLAMP AS PER DWG.***								
	***VERIFY BY <u>38</u> BATCH # TO MATCH W/O								
	<u>150441</u> <u>DAS9-89</u>								
	***VERIFY BY <u>38</u> PART # TO MATCH								
	W/O <u>150441</u> <u>8-89</u>								
150	Packaging	0.00							
150									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D119-796-151								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.02							
Quality Control									

DAS
38
9-89
NOV 2 0 2016

16-11-28

16/11/29

16-11-28

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Picklist Print

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Parent Item: D119-796-151

D119-796-151

Parent Item Name: FWD Crosstube Installation with Step (no hardware)

Start Date: 8/16/2016

Required Date: 9/12/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.09.09 NEW ISSUE DD VERF:JLM IPP
REV:B 14.11.19 AS PER REV.C DD VERF:JLM IPP REV:C
14.12.09 AS PER REV.PC6 DD VERF:JLM IPP REV:D 15-02-11
AS PER REV D JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D119-796-141		Manufactured	No				Each	0.0000		1			
D119-796-141									**	<u>1</u>			MA
FWD Crosstube Installation without Step (no hardware)												16-11-15	
D5123-3		Manufactured	No				Each	100.0000		4			
D5123-3									**				MA
Clamp Cushion												16-11-27	
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
LG054				150315			12			<u>4</u>			
				147939			12						
LG055							88						
				146879			28						
				148184			24						
				149113			36						
D5149-041		Manufactured	No				Each	4.0000		2			
D5149-041									**				MA
Fwd Step Base Assembly												16-11-27	
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
LG051							2						
				142764			2						
LG055							2						
				142766			2						
				152462						<u>2</u>			

DQA: _____ Date: _____

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Parent Item: D119-796-151

D119-796-151

Parent Item Name: FWD Crosstube Installation with Step (no hardware)

Start Date: 8/16/2016

Required Date: 9/12/2016

Start Qty: 1.00

Required Qty: 1.00

MS21920-22

Purchased

No

Each

22.0000

4

MS21920-22

Clamp

16.11.27

Location

Loc Qty

Loc Code

LG050

22

M135309

22

135544

4

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



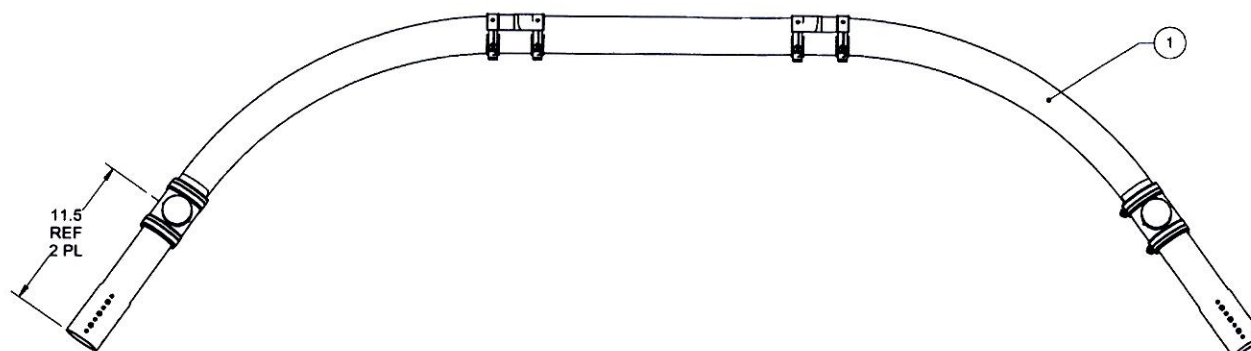
QA Closed: _____ Date: _____

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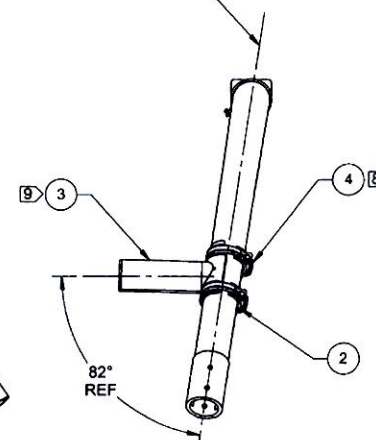
ITEM	QTY	P/N	DESCRIPTION
	X	D119-796-151	XTUBE ASSY (AW119 MKII FWD)
1	1	D119-796-141	XTUBE ASSY (AW119 MKII FWD)
2	4	D5123-3	CUSHION
3	2	D5149-041	FWD STEP ASSEMBLY
4	4	MS21920-22	CLAMP

SHOP COPY
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 150441 MJS
16-08-29



D119-796-151 XTUBE ASSY (AW119 MKII FWD)

D119-796-141 XTUBE
BENDING PLANE



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.5
- 7) WEIGHT: 19.87 lbs
- 8) TORQUE MS21920-22 CLAMPS TO 50 IN-LBS MAX
- 9) LOCATE STEP USING POST FITTING ON CROSSTUBE

RELEASED

2015 FEB 09

ECN 15-516

D	D5123-3 CLAMP CUSHION WAS D5123-9 CLAMP CUSHION, MS21920-22 WAS -24.	AP	15.01.19
C	RE-DESIGN STEP INSTALLATION	DB	14.11.24
B	D5149-043 WAS D5149-041, AN4C6A WAS AN4C10A, D2274 WAS D5153-1	AP	14.11.04
A	NEW ISSUE	AP	14.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	DB	DRAWING NO. REV. D	
MFG. APPR.	JLM	D119-796-151 SHEET 1 OF 1	
APPROVED	HS	TITLE SCALE	
DE APPR.	DS	XTUBE ASSY (AW119 MKII FWD) NTS	
DATE	15.01.19	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SHOWN ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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